

Work Order ID 151981***151981***

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Friday, October 14, 2016 1:56:30 PM

Item ID: D119-796-151 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: FWD Crosstube Installation with Step (no hardware)
Start Date: 10/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								
110	Document Control	0.00							
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-151 chg 004								
120	Pick Kit	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging									
130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.11							
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								
	Torque all clamps to 50 IN-LBS max.								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***RE-CHECK TORQUE ON CLAMP AS PER DWG.*** ***VERIFY BY <u>151981</u> <u>38</u> BATCH # TO MATCH W/O ***VERIFY BY <u>151981</u> <u>38</u> PART # TO MATCH W/O <u>151981</u> <u>38</u>	0.00 0.00				1			DAS 38 9-89 JAN 30 2017
150 *150* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D119-796-151 Au1	0.00 0.00				1			DAS 41 9-89 17-1-30
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							17/01/30 JF 17-1-30

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 10/28/2016**Required Date:** 11/23/2016

Start Qty: 1.00

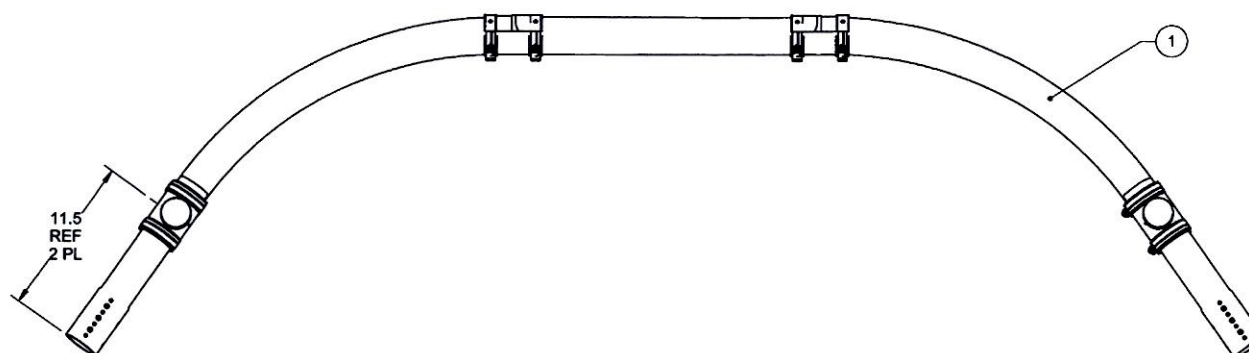
Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV :D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1			
D119-796-141 FWD Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	126.0000		4			
D5123-3 Clamp Cushion													
				<u>Location</u>			<u>Loc Qty</u>						
				LG055			126						
				149113			16						
				149671			12						
				150315			48						
				151097			50			4			
D5149-041		Manufactured	No				Each	6.0000		2			
D5149-041 Fwd Step Base Assembly													
				<u>Location</u>			<u>Loc Qty</u>						
				LG055			6						
				148204			6						
MS21920-22		Purchased	No				Each	82.0000		4			
MS21920-22 Clamp													
				<u>Location</u>			<u>Loc Qty</u>						
				LG050			82						
				M135544			32						
				M135603			50			4			

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151981 MJS
16-10-17



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516 P

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.08.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO. REV. D	
MFG. APPR.	JLM	D119-796-151 SHEET 1 OF 1	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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